

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009832**Date Inspected:** 19-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Chuan Ging , Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower/OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY #10

This QA Inspector randomly observed the following work in progress.

SOUTH TOWER LIFT #4

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052075 performing Flux Core Arc Welding process for the weld joint SSTL4-1J/L -092 located on PCMK South tower lift #4. ZPMC QC Mr. Jiang Bo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 050041 performing Flux Core Arc Welding process for the weld joint SSTL4-1K/L -025 located on PCMK South tower lift #4. ZPMC QC Mr. Jiang Bo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057266 performing Flux Core Arc Welding process for the weld joint SSTL4-1G/L -094 located on PCMK South tower lift #4. ZPMC QC Mr. Liu Zhong An monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057266 performing Flux Core Arc Welding process for the weld joint SSTL4-1H/L -07 located on PCMK South tower lift #4. ZPMC QC Mr. Liu Zhong An monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

NORTH TOWER LIFT #3

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040343 performing Flux Core Arc Welding process for the weld joint NSTL3-3B/K -084A located on PCMK North tower lift #3. ZPMC QC Mr. Chen Ying Xin monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair. The weld repair report identified as T-WR2016 and Ultrasonic testing (UT) report identified as T787-UT-4146.

BAY #11

This QA Inspector randomly observed the following work in progress.

EAST TOWER LIFT #4

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040713 performing Flux Core Arc Welding process for the weld joint ESTL4-2H/L -60 located on PCMK East tower lift #4. ZPMC QC Mr. Li Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

BAY #14

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 10AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066673 performing Flux Core Arc Welding process for the weld joint SEG059*-007 located on PCMK splice weld between DP262A and DP235A. ZPMC QC Mr. Xu Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1T-2.

OBG SEGMENT 09BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045265 performing Submerged Arc Welding process for the weld joint SEG051*-034 located on PCMK splice weld between DP231A and DP258A. ZPMC QC Mr. Xu Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1T-2.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
